

Work Order ID 86585

\*86585\*

Page 1

July-05-12 1:14:25 PM

Item ID: D2989-043

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Basket Lid Assembly

Stop

\*NS2\*

Start Date: 7/05/12 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: CD

Date: 12/07/05 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2989	Rev D

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs in DT9446 jig, weld as per dwg D2989  
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig  
3- to locate hinges and shims use D2989-041, weld as per dwg D2989  
A/R ER316 S.S. Rod Batch: M122130

PL 12.12.17

1X

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

Memo

0.00

QC

Quality Control

DA  
23  
89  
12.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 7/05/12 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

DAS  
15  
8-89

DAS  
09  
8-89

\*120\*

QC

Quality Control

12/18

125

Pressure Wash per QSI005 4.3

0.00

\*125\*

HandFinish

Hand Finishing

Memo

0.00

1 12/18 12-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*NS1\*

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\*NS2\*

Item Name: Basket Lid Assembly

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\*1\*

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Required Date: 8/03/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

\*130\*

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg  
D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

1'00)  
4000F

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2'00  
4000F  
2'30

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Quality Control

Memo

0.00

LX

12/12/18

W123383

1 φ 12-12-18 280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 86585**

**\*86585\***

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**Item ID:** D2989-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Basket Lid Assembly

Stop

**\*NS2\***

**Start Date:** 7/05/12    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 8/03/12    **Req'd Qty:** 1.00    **\*1\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start

**\*NR1\***

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**  
150

**Operation  
Description**  
Identify as per dwg & Stock Location:  
*D350-604043*

**Set Up/  
Run Hours**

**Tool ID** 87538  
**Tool #**

**Plan  
Code:**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

**\*150\***

Packaging

Packaging

**Memo**

0.00

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Quality Control

**Memo**

0.00

*13/19/08*

*MF  
12-12-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Work Order ID: 86585

Parent Item: D2989-043

Start Date: 7/05/12

Required Date: 8/03/12

Parent Item Name: Basket Lid Assembly

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM

IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC

IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC

IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000	1	1	24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA			8						
					83907		8						
D2989-3 Rib		Manufactured	No			100	Each	5.0000	1	1	DAS 24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA			4						
					77527		4						
				WA005			1						
					72408		1						
D2989-4 Rib		Manufactured	No			100	Each	5.0000	1	1	DAS 24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA005			5						
					72409		1						
				WA005			4						
D2989-5 Rib		Manufactured	No			100	Each	4.0000	2	2	DAS 24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA			3						
					81911		3						
				WA005			1						
					71222		1						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID:** 86585

**Parent Item:** D2989-043

**Parent Item Name:** Basket Lid Assembly

**Start Date:** 7/05/12

**Required Date:** 8/03/12

**Start Qty:** 1.00

**Required Qty:** 1.00

D3182-1

Hinge

Manufactured No 100 Each 12.0000 2

2 34 12.12.12  
B 301 DAS → 6

D3442-3

Shim

Manufactured No 100 Each 14.0000 2

2 34 12.12.12  
B 79/23 → 6

D3827-041  
Rib Assembly (Inboard)

Manufactured No 100 Each 11.0000 1

1 34 12.12.12  
B 875/97 → 10

D3832-5  
Mesh (Lid)

D3833-5  
Mesh (Lid End)

Manufactured No 100 Each 0.0000

B 77756 → 1 12.12.12  
DAS 24 8.89

Manufactured No 100 Each 38.0000

B 67461 → 2 12.12.12  
DAS 24 8.89

D3838-041  
Rib Assembly (Basket Lid, LH)

Manufactured No 100 Each 5.0000 1

1 34 12.12.12  
B 891333 → 11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA035	38	
67461	38	
WA005	5	
77525	5	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Work Order ID: 86585

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3838-042

Rib Assembly (Basket Lid, RH)

Manufactured No 100 Each 5.0000 1

1 24 12-12-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA005	5	
72415	1	
77526	4	

FB 84-798

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, LID END
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

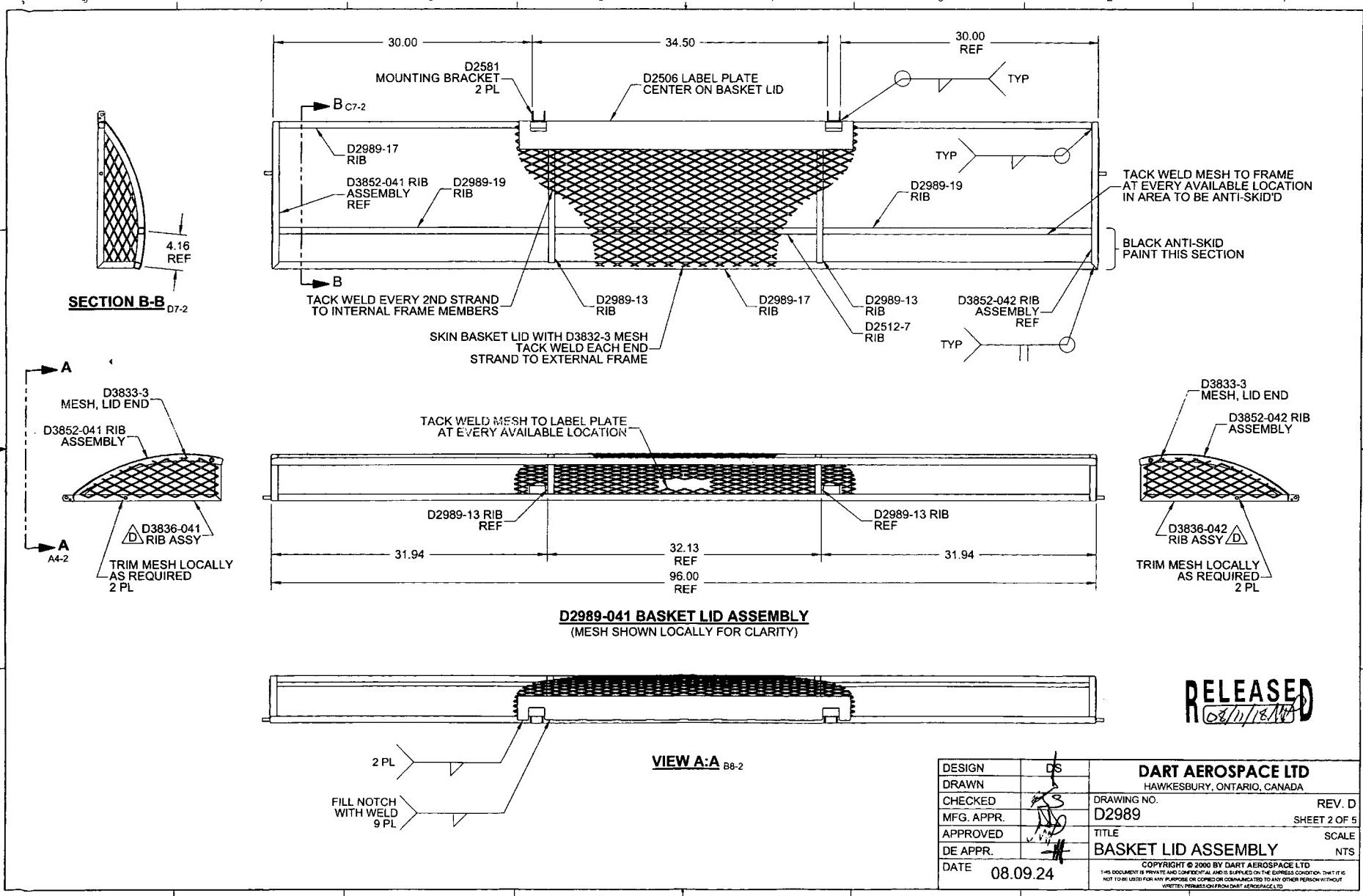
**RELEASED**  
*08/11/18 MHD*

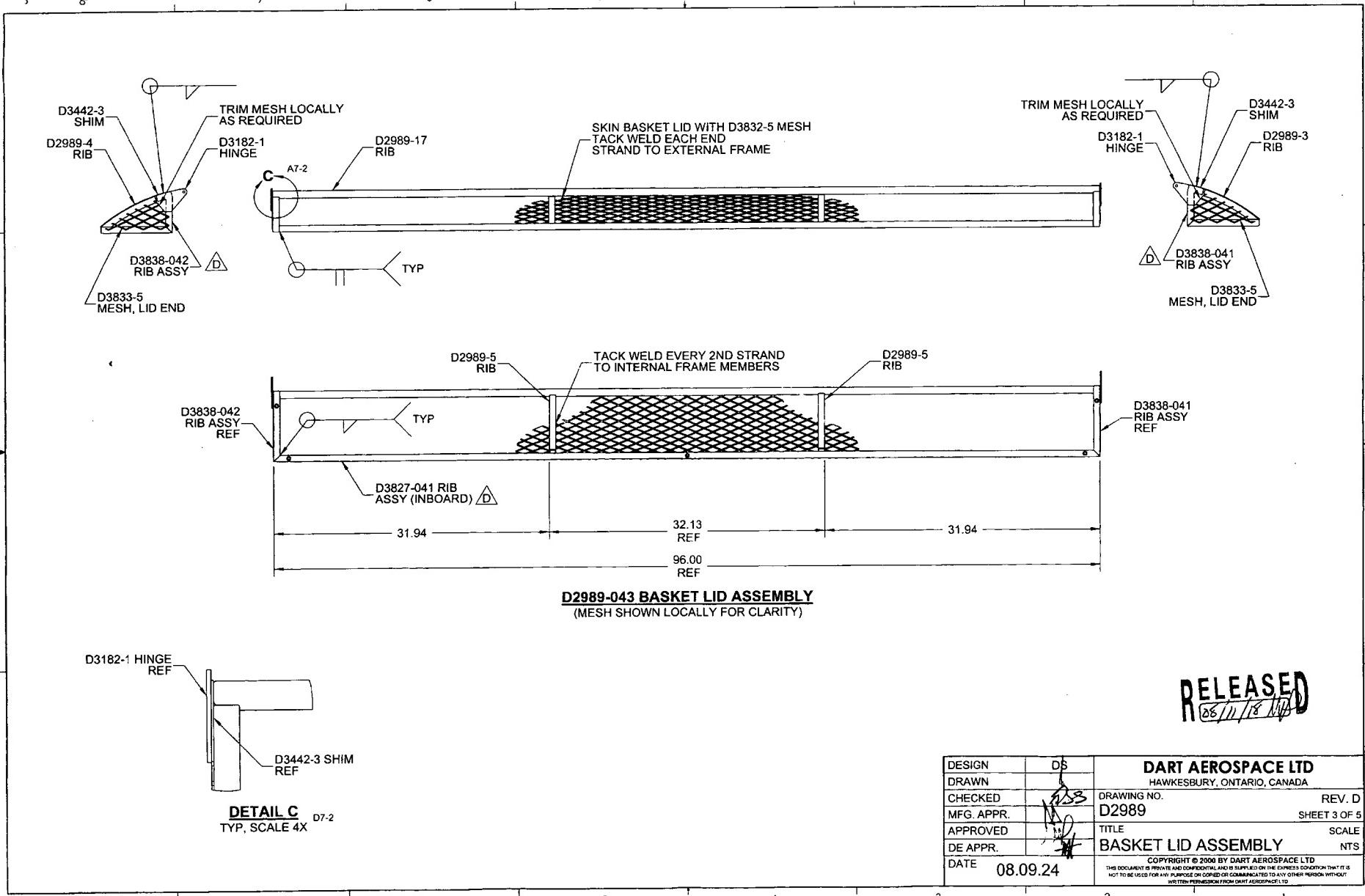
*C812107105*  
*WTO: 86585*

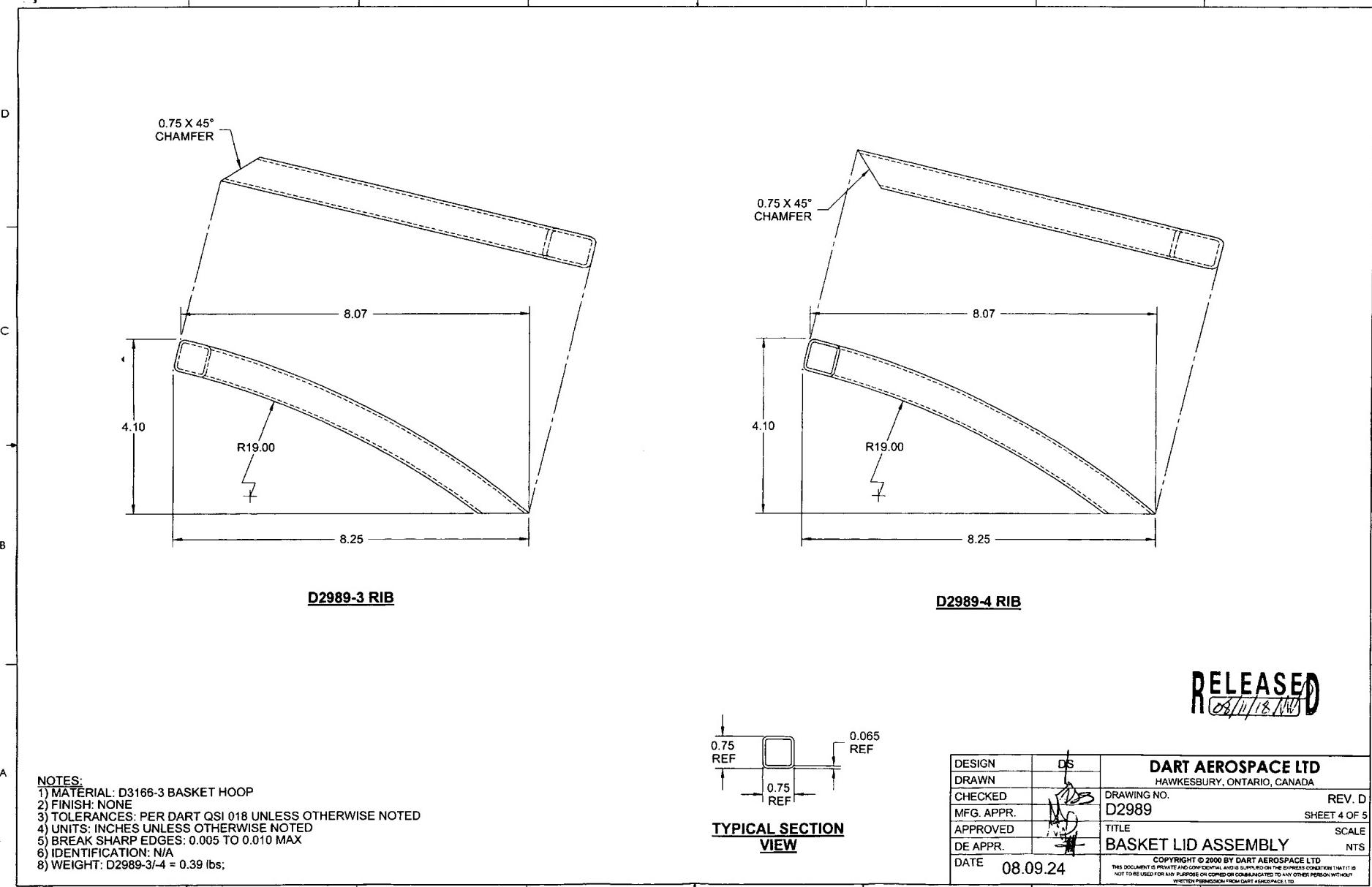
**NOTES:**

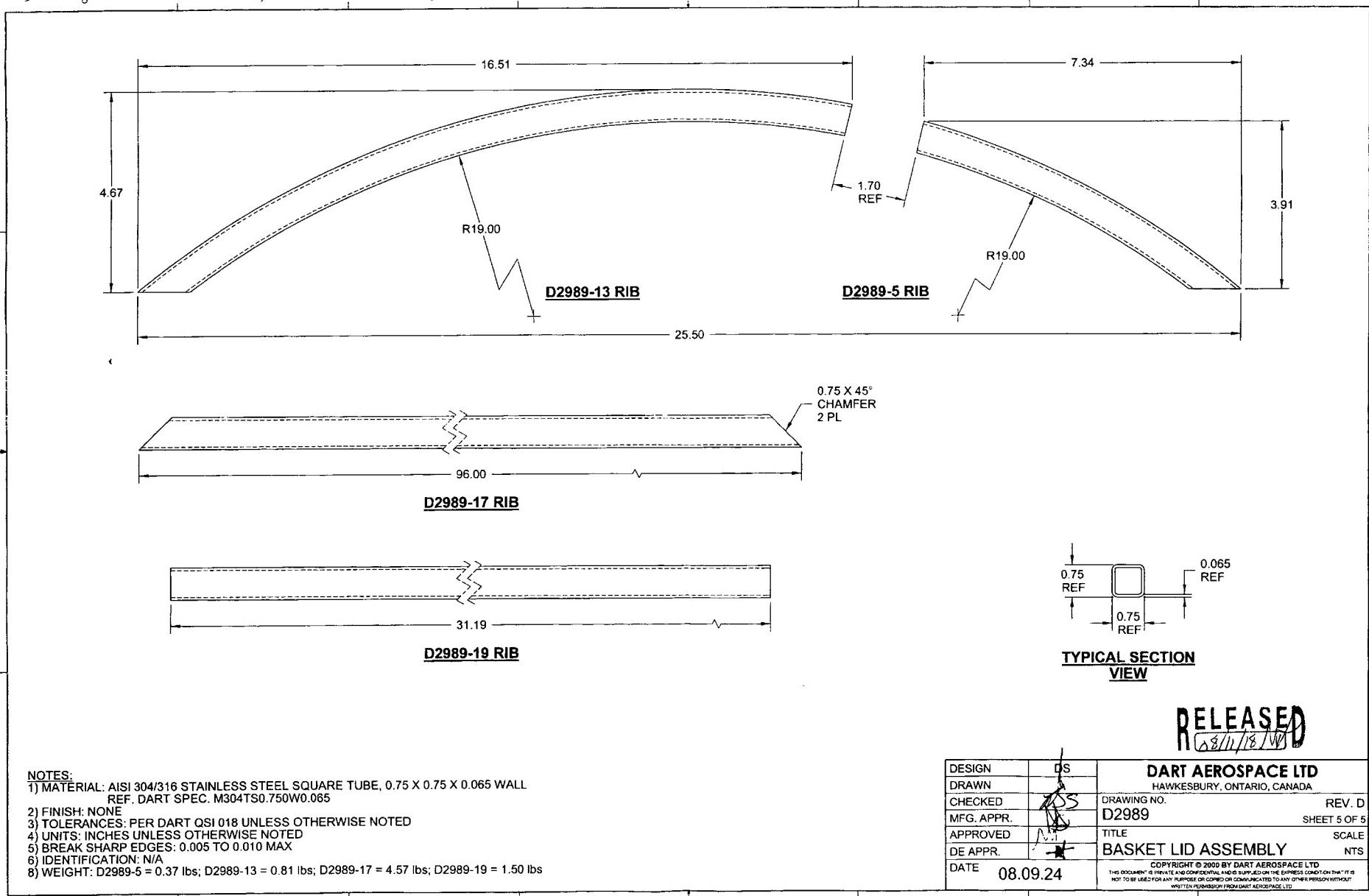
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). D3836-041 REPLACES D2989-1/2-7-15, D3838-041 REPLACES D2989-1/2-7-17, D3838-042 REPLACES D2989-1/2-7-16, D3852-041 REPLACES D2989-11; D3838-042 REPLACES D2989-11-12. D3836-042 REPLACES D2989-2; REMOVED D2989-3 (NOW INSTALLED ON D3836 DWG), D2989-9/10 (NOW ON D3838 DWG), D2989-1/2-7-15 (NOW ON D3838 DWG) AND D2989-11/12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	<i>RS</i>	D2989	SHEET 1 OF 5
MFG. APPR.	<i>RS</i>	TITLE	SCALE
APPROVED	<i>WHD</i>	BASKET LID ASSEMBLY NTS	
DE APPR.	<i>WHD</i>	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED OR COMMUNICATED TO ANOTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		









**RELEASED**  
*(8/11/18)*